

FIG.1

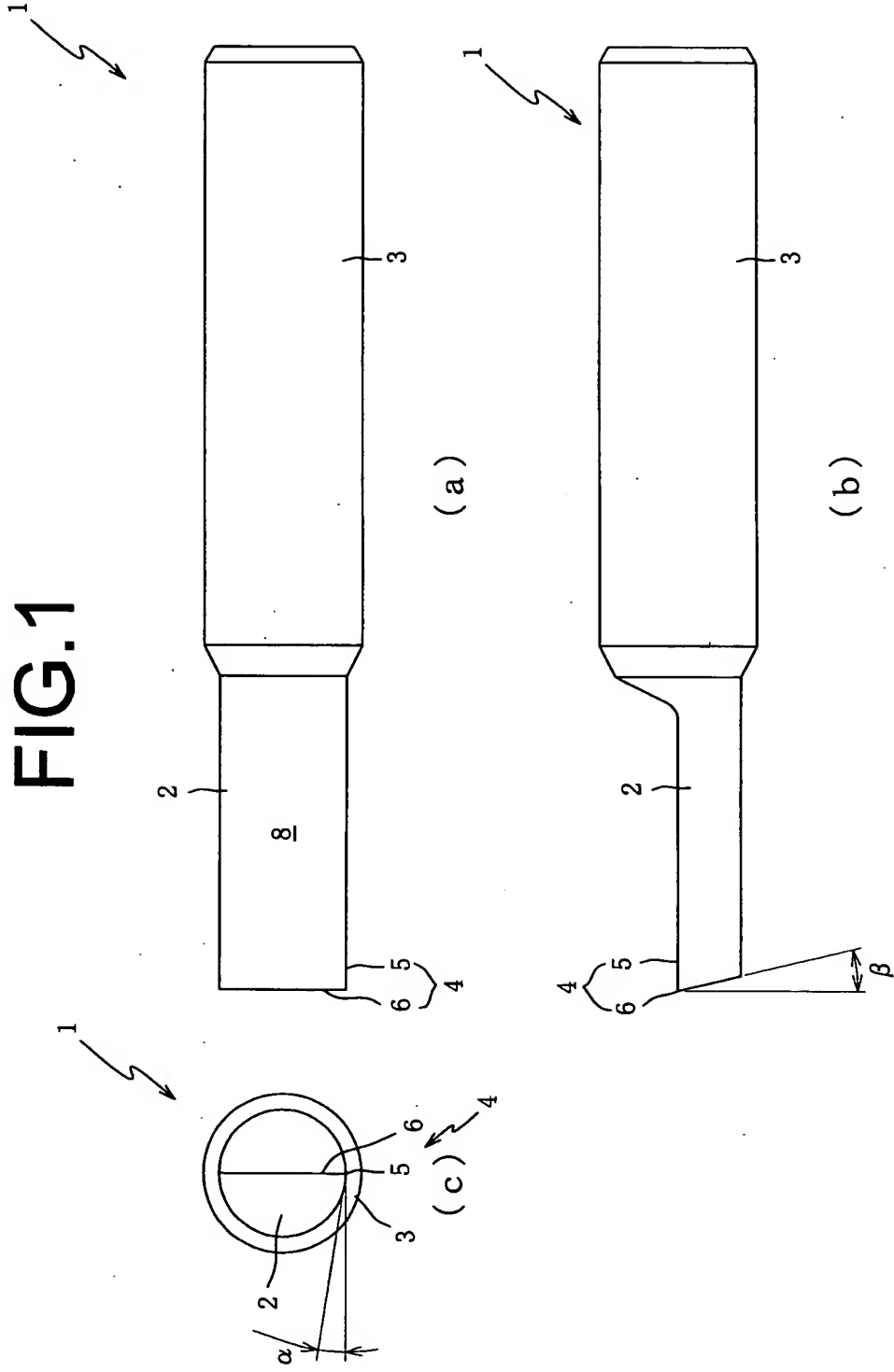


FIG. 3

	NON-ROTARY CUTTING TOOL	END MILL
ROUGHNESS OF MACHINED SURFACE	0.4 μm Rz	2.0 μm Rz
RADIUS OF CURVATURE	0.03 mm	0.05 mm
PERPENDICULARITY	0.9 μm	4.9 μm

FIG. 2

		NON-ROTARY CUTTING TOOL	END MILL
SHANK DIAMETER		10 mm	10 mm
WIDTH OF CUT		8 mm	8 mm
NUMBER OF TEETH		1	6
LENGTH OF CUT		15 mm	18 mm
BASE MATERIAL		K10	K10
COATING		DIAMOND COATING (GROUND AFTER ITS FORMATION)	DIAMOND COATING
SURFACE ROUGHNESS		0.4 μm Rz	2.0 μm Rz
NOSE RADIUS		0.03 mm	0.03 mm
PERPENDICULARITY		0.9 μm	2 μm
RADIUS ON CUTTING EDGE		0.01 μm	0.04 μm
CUTTING CONDITION	ROTATION SPEED	NOT ROTATED	2000 r.p.m.
	FEED RATE	6000 mm/min	6000 mm/min
	DEPTH OF CUT	0.01 mm	0.01 mm
	WORK MATERIAL	ADC12	
	USED MACHINE	HORIZONTAL-TYPE MACHINING CENTER	
	TOOL HOLDER	COLLET MILLING CHUCK	
	CUTTING FLUID	WATER SOLUBLE FLUID	

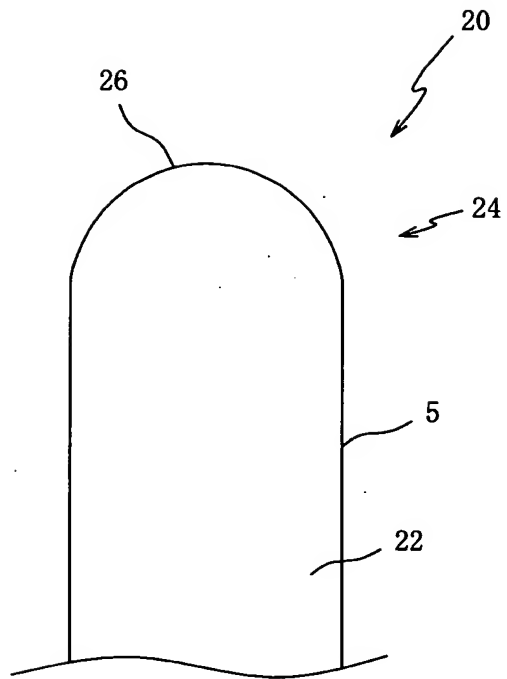


FIG. 4A

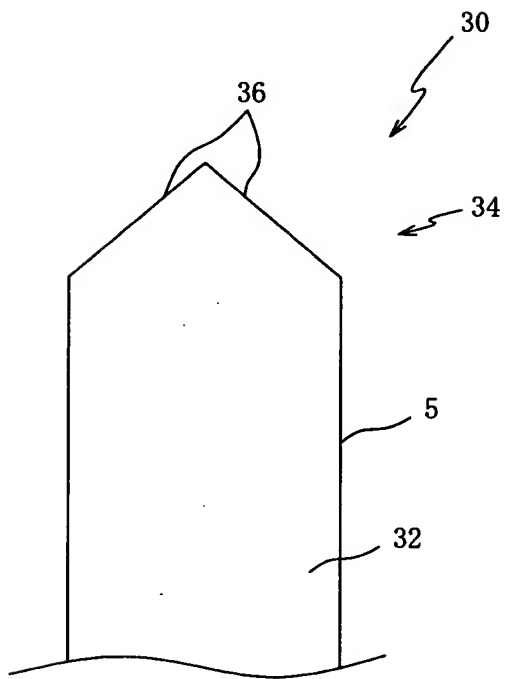


FIG. 4B

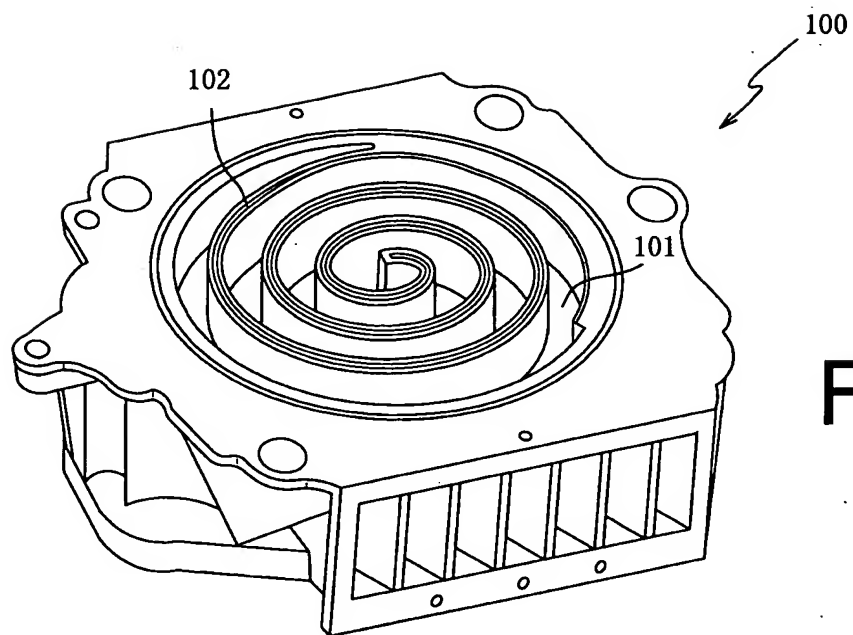


FIG. 5A

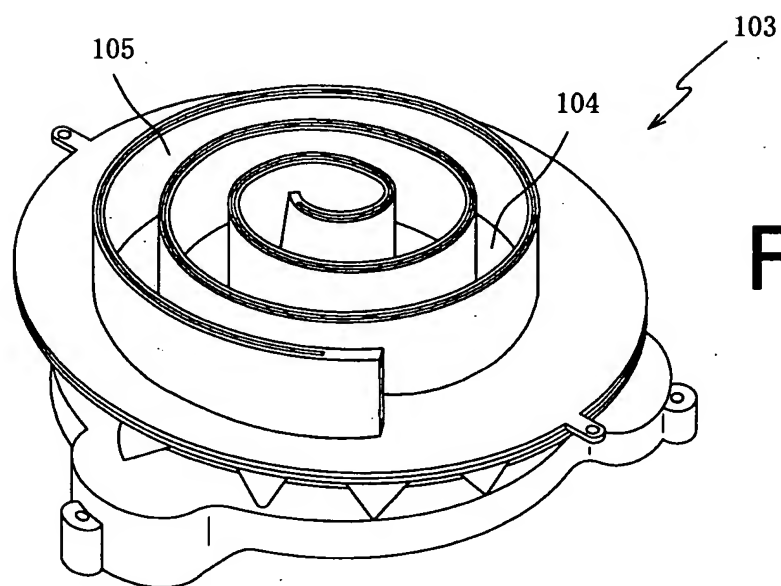
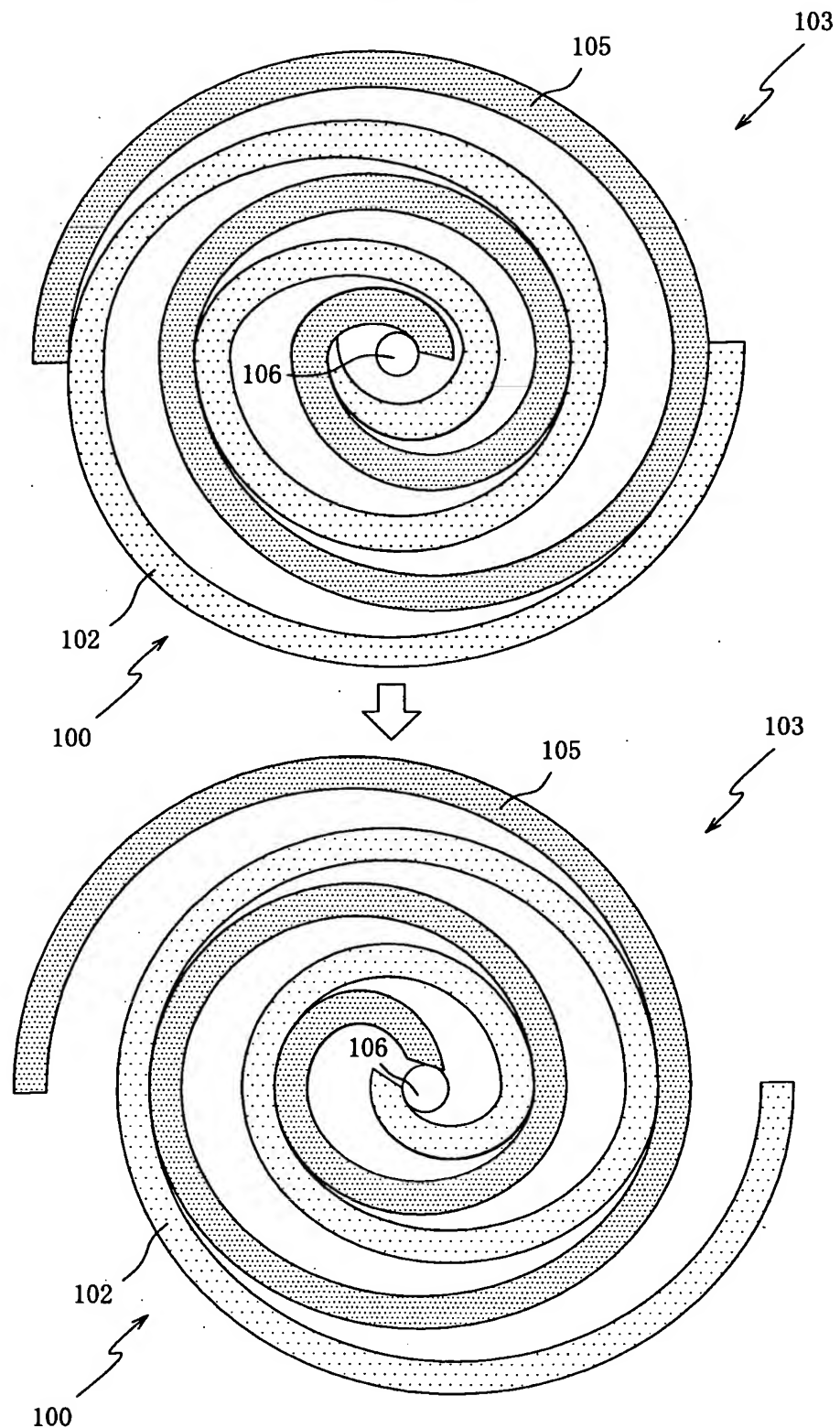


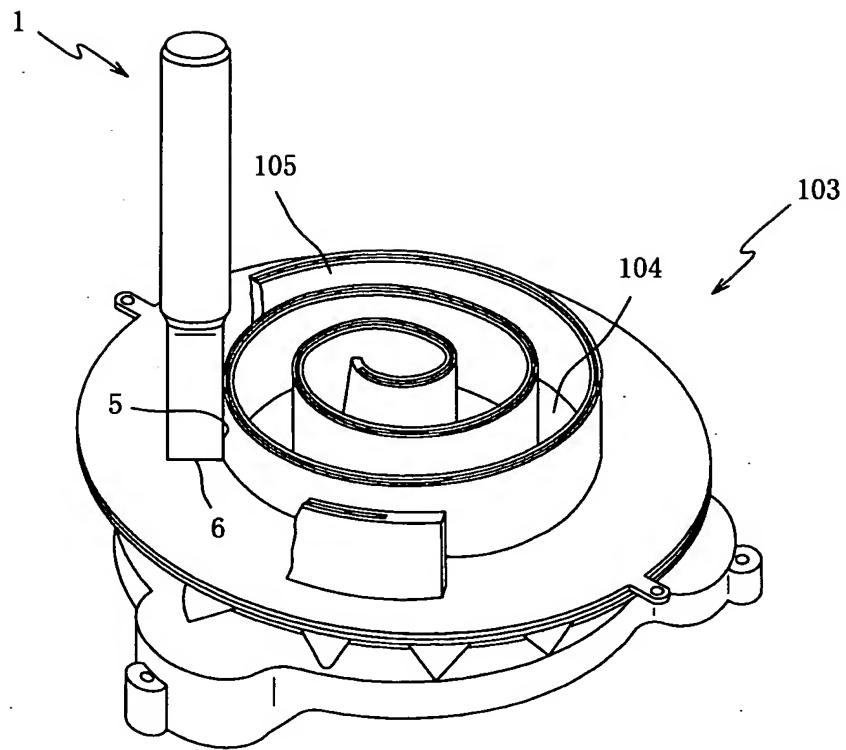
FIG. 5B

FIG.6



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FIG.7



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